

Date: Thursday, 12/14/2006 3:39:26 PM

User: Kim Johnston

## Process Sheet

|                                                                                                                 |                                     |
|-----------------------------------------------------------------------------------------------------------------|-------------------------------------|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services                                                           | <b>Drawing Name</b> : WEARPLATE     |
| <b>Job Number</b> : 29960                                                                                       |                                     |
| <b>Estimate Number</b> : 10298                                                                                  |                                     |
| <b>P.O. Number</b> : <i>N/A</i>                                                                                 | <b>Part Number</b> : D25773         |
| <b>This Issue</b> : 12/14/2006 <b>S.O. No.</b> : <i>N/A</i>                                                     | <b>Drawing Number</b> : D2577 REV E |
| <b>Prsht Rev.</b> : NC                                                                                          | <b>Project Number</b> : N/A         |
| <b>First Issue</b> : <i>N/A</i> <b>Type</b> : SMALL /MED FAB                                                    | <b>Drawing Revision</b> : E         |
| <b>Previous Run</b> : 29326                                                                                     | <b>Material</b> : <i>N/A</i>        |
| <b>Written By</b> : <i>[Signature]</i>                                                                          | <b>Due Date</b> : 1/10/2007         |
| <b>Checked &amp; Approved By</b> : <i>[Signature]</i>                                                           | <b>Qty:</b> 30 <b>Um:</b> Each      |
| <b>Comment</b> : Est: F 02.09.24 Re-format; Incorporated D2577-101/-13 KJ/<br>RF<br>Est. C 06.07.21 waterjet EC |                                     |

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S16GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.9240 sf(s)/Unit Total : 27.7200 sf(s)

1010/1025/A21/6aA SHEET 0.063 thick

Batch: *11-103069 M103069 M1 07 01 03*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut D2577-101 as per Dwg D2577

Dwg Rev: *E*Prog Rev: *E**M1 07 01 03**(30)*

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

*M1 07 01 03**(30)*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*11/07/01/03 (30)*

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr

*SAH 07/01/07 30*

## WORK ORDER CHANGES

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/02/12

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 3:39:27 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 29960

Part Number: D25773

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake as per Dwg D2577 using DT8155 and DT8179

2-Identify as D2577-3

SB 07/01/05 30

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

207-01-26 (30)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description

Batch

A/R 7560 Hardcoat Rod

M103030

FC 070130 (30)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

1207/02/06 (30)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

N/101601

M-H/Y 07/02/08

(30X)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 07/02/08

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP19

Y 07/02/09

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(30)  
07/02/12  
07/02/09

Job Completion



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



RELEASED  
00.09.22

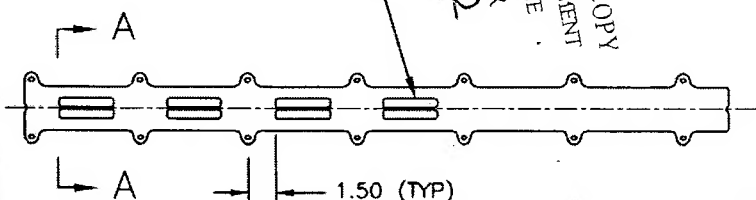
| DESIGN           | DRAWN BY          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA | REV. E       |
|------------------|-------------------|---------------------------------------------------|--------------|
| CHECKED          | APPROVED          | DRAWING NO.<br>D2577                              | SHEET 1 OF 5 |
| DATE<br>00.09.22 | TITLE<br>WEARSHOE | SCALE<br>1:10                                     |              |
| A                | 96.09.16          | NEW ISSUE                                         |              |
| B                | 96.12.04          | ADD HARDCOAT WELDS                                |              |
| C                | 97.05.30          | CHANGE HOLES TO OBROUNDS                          |              |
| D                | 98.08.17          | CORRECTED DIMENSIONS ON -1 & -3                   |              |
| E                | 00.09.22          | ADD D2577-101/-11/-13<br>INCORPORATE DE09176      |              |

7560 HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308



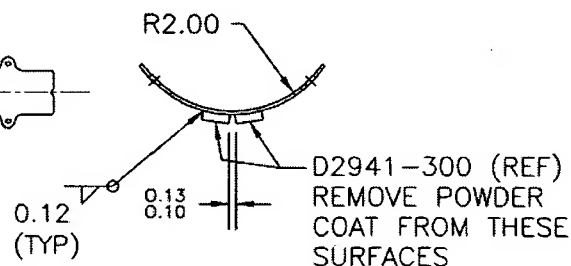
D2577-1 & D2577-3 WEARSHOE  
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY  
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300  
SHWAYDER WEAPADS  
(8 PLACES)



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WORK ORDER  
NO. 29460

SECTION A-A  
SCALE 1:5

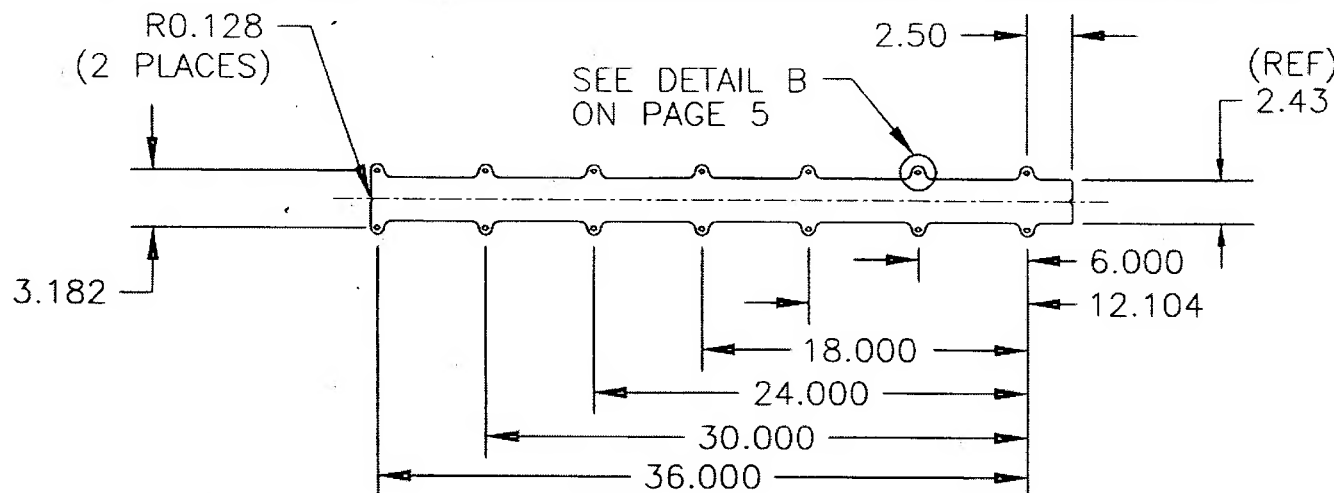


D2577-21 & D2577-23 WEARSHOE  
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY  
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



| DESIGN             | DRAWN BY           | DRAWING NO. | REV. E       |
|--------------------|--------------------|-------------|--------------|
| <i>[Signature]</i> | <i>[Signature]</i> | D2577       | SHEET 2 OF 5 |
| CHECKED            | APPROVED           | TITLE       | SCALE        |
| <i>[Signature]</i> | <i>[Signature]</i> | WEARSHOE    | 1:10         |
| DATE               |                    |             |              |
| 00.09.22           |                    |             |              |

RELEASED  
00.09.26

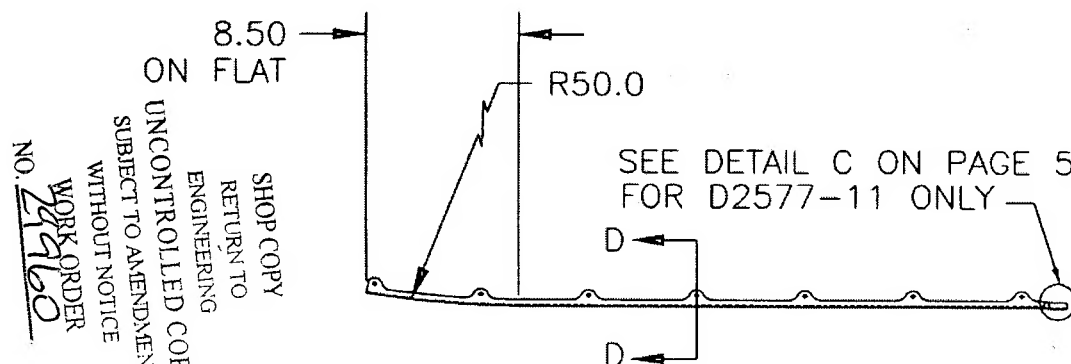


### D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



### D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

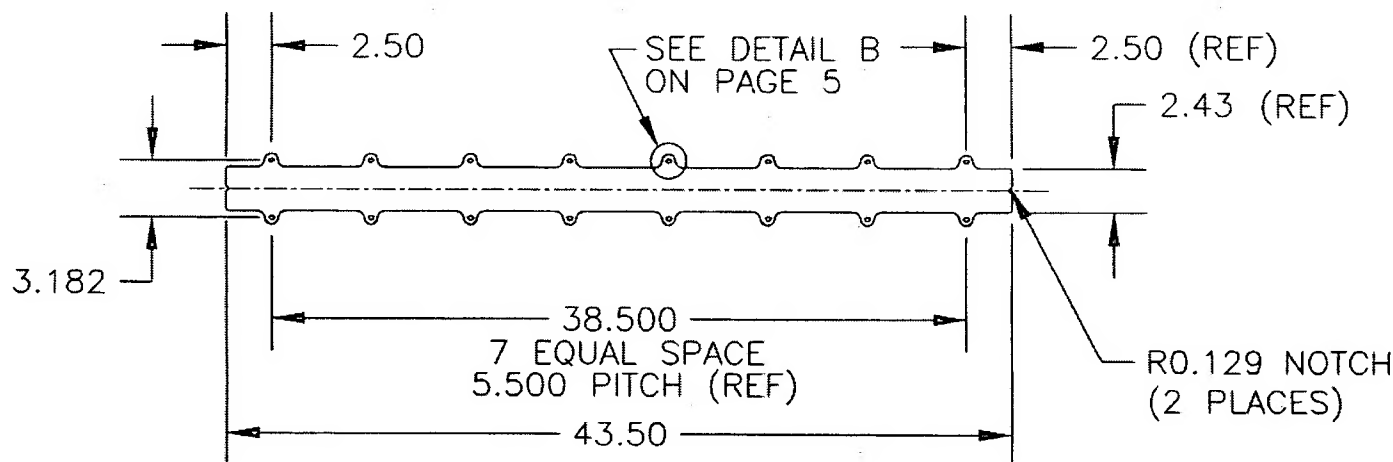
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



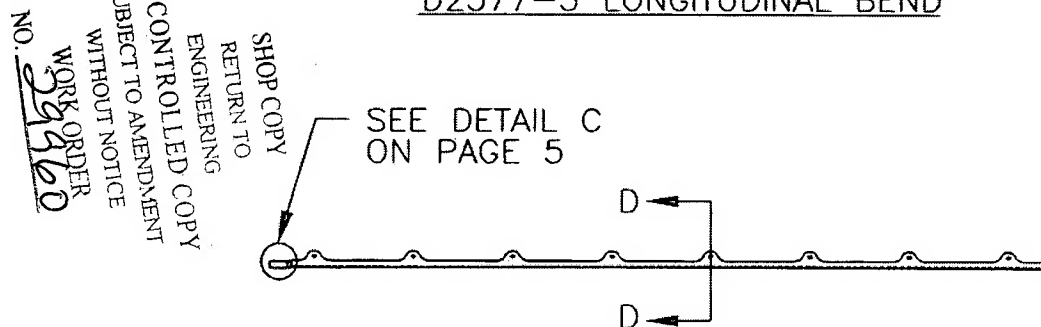
|          |             |                             |
|----------|-------------|-----------------------------|
| DESIGN   | DRAWN BY    | DART AEROSPACE LTD          |
| CHECKED  | APPROVED    | HAWKESBURY, ONTARIO, CANADA |
| DATE     | DRAWING NO. | REV. E                      |
| 00.09.22 | D2577       | SHEET 3 OF 5                |
|          | TITLE       | SCALE                       |
|          | WEARSHOE    | 1:10                        |

RELEASED  
00.09.26

### D2577-5 FLAT PATTERN



### D2577-5 LONGITUDINAL BEND



### D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

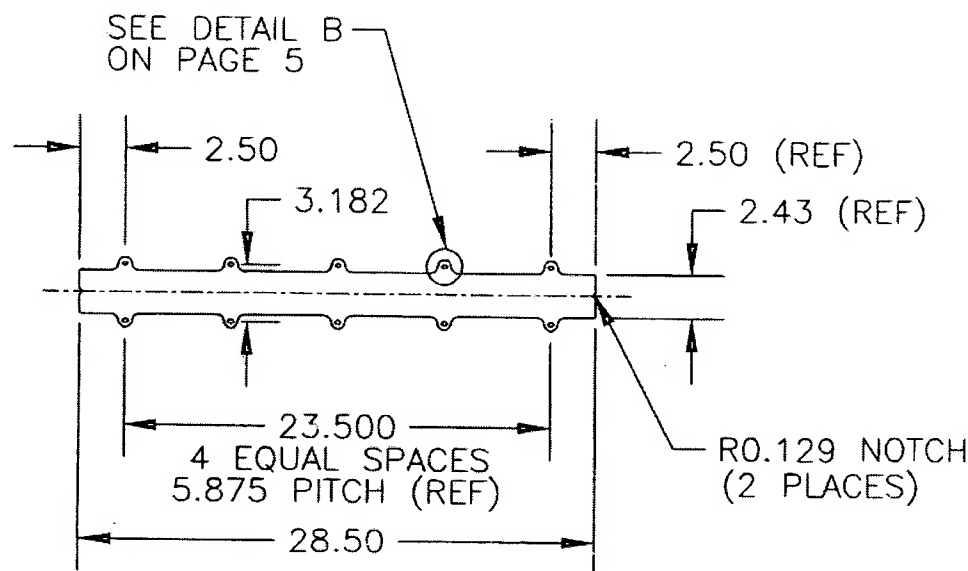
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



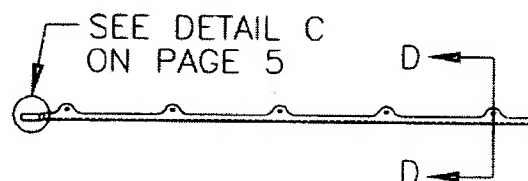
| DESIGN        | DRAWN BY | DART AEROSPACE LTD | REV. E       |
|---------------|----------|--------------------|--------------|
| CHECKED       | APPROVED | DRAWING NO. D2577  | SHEET 4 OF 5 |
| DATE 00.09.22 |          | TITLE WEARSHOE     | SCALE 1:10   |

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00.09.26

### D2577-7 FLAT PATTERN



### D2577-7 LONGITUDINAL BEND



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### D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

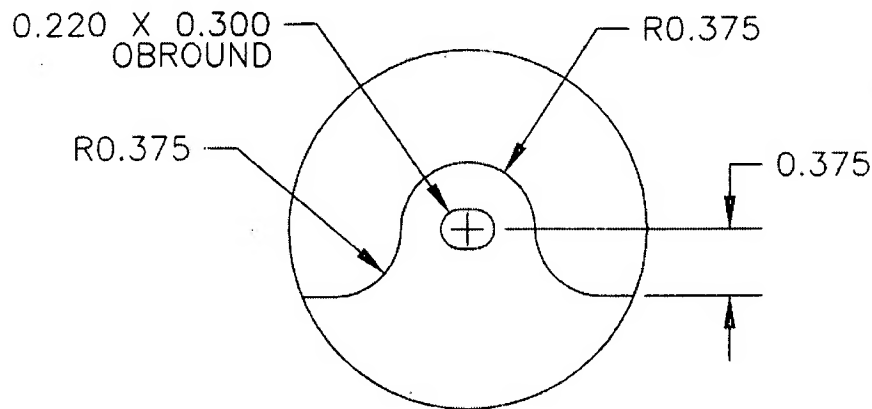




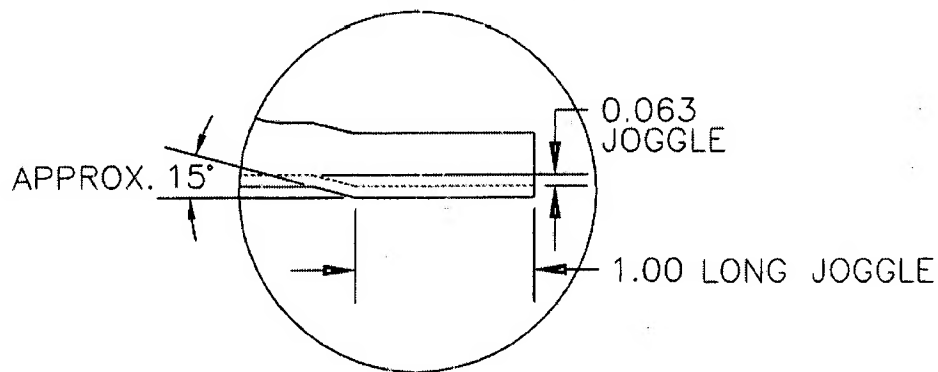
|                  |                |                                                   |                        |
|------------------|----------------|---------------------------------------------------|------------------------|
| DESIGN<br>#      | DRAWN BY<br>UP | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>#     | APPROVED<br>#  | DRAWING NO.<br>D2577                              | REV. E<br>SHEET 5 OF 5 |
| DATE<br>00.09.22 |                | TITLE<br>WEARSHOE                                 | SCALE<br>1:10          |

RELEASED  
00.09.22

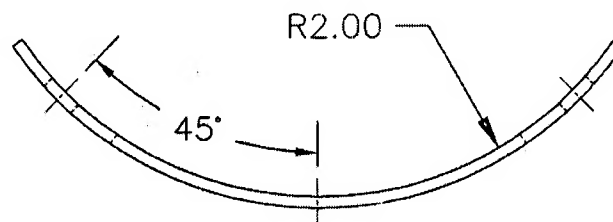
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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